

# Work Order ID 82376

March-30-12 7:43:20 AM

**\*82376\***

Page 1

Item ID: D2804-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Bracket Assembly

Stop **\*NS2\***

Start Date: 29/03/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/30

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2804	Rev C
-------	-------

100

**\*100\***

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Press D2805-1 Into arm as per Dwg D2804

8X

12/10/02

110

**\*110\***

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

SmB  
12/10/01

DAG  
16  
9-83  
17/10/02

8

120

**\*120\***

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1'-45

3200F

2'-15

8X

12/10/02

ML21878

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82376

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Page 2

Item ID: D2804-041

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Bracket Assembly

Stop **\*NS2\***

Start Date: 29/03/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC3- Inspect Part Finish

0.00

**\*130\***

QC

Memo

0.00

Quality Control

8 of 12-10-2

140

Small Fab

0.00

**\*140\***

Small Fab

Memo

0.00

Small Fab

Press D2809 into arm as per Dwg D2804

8x 12/10/03

150

Small Fab

0.00

**\*150\***

Small Fab

Memo

0.00

Small Fab

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 2-Assemble as per Dwg D2804.

8x 12/10/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 82376**

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**\*82376\***

Page 3

Item ID: D2804-041  
Revision ID:  
Item Name: Bracket Assembly  
Start Date: 29/03/2012 Start Qty: 4.00  
Required Date: 12/04/2012 Req'd Qty: 4.00  
Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		17/02/04		(48)			
170 <b>*170*</b> Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00  0.00		ST148					12/10/14 (8)
180 <b>*180*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							12/10/15 78 ME 12-10-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-30-12 7:43:24 AM

Page 1

Work Order ID: 82376

Parent Item: D2804-041

Parent Item Name: Bracket Assembly

\*82376\*

\*D2804-041\*

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3KJ/JLM  
IPP Rev:G As per Rev C 06-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2804-1 *D2804-1* Bracket		Manufactured	No			100	Each	1.0000	1	4	**	12/10/01	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST148				1					
					79083			1					
D2805-1 *D2805-1* Stop		Manufactured	No			100	Each	10.0000	1	4	**	12/10/01	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				10					
					79525			10					
NAS1515H3 *NAS1515H3* Washer		Purchased	No			100	Each	194.0000	4	16	**	12/10/03	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST277				194					
				118078				6					
				118384				11					
				119438				4					
				120142				47					
				120518				26					
				120770				100					

B85925 (8x)

B83942 (8x)

M121415  
32x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

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Page 2

Work Order ID: 82376

Parent Item: D2804-041

Parent Item Name: Bracket Assembly

\*82376\*

\*D2804-041\*

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 4.00

Required Qty: 4.00

AN3C16A

Purchased

No

150

Each

65.0000

2

8

\*\*

\*AN3C16A\*

Bolt

## Location

## Loc Qty

## Loc Code

ST352

65

115835

1

118422

4

120498

60

D2809

Manufactured

No

150

Each

51.0000

1

4

\*\*

\*D2809\*

Bushing

## Location

## Loc Qty

## Loc Code

GA

35

72735

7

80557

28

ST018

16

34035

12

77292

4

MS21043-3

Purchased

No

150

Each

613.0000

2

8

\*\*

\*MS21043-3\*

Nut

## Location

## Loc Qty

## Loc Code

FG

72

103691

72

GA

270

120693

270

ST301

271

118077

2

118614

219

118686

30

119758

20

12/10/03

M122814(16x)

12/10/03

385299(8x)

12/10/03

M121708  
16x

March-30-12 7:43:24 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

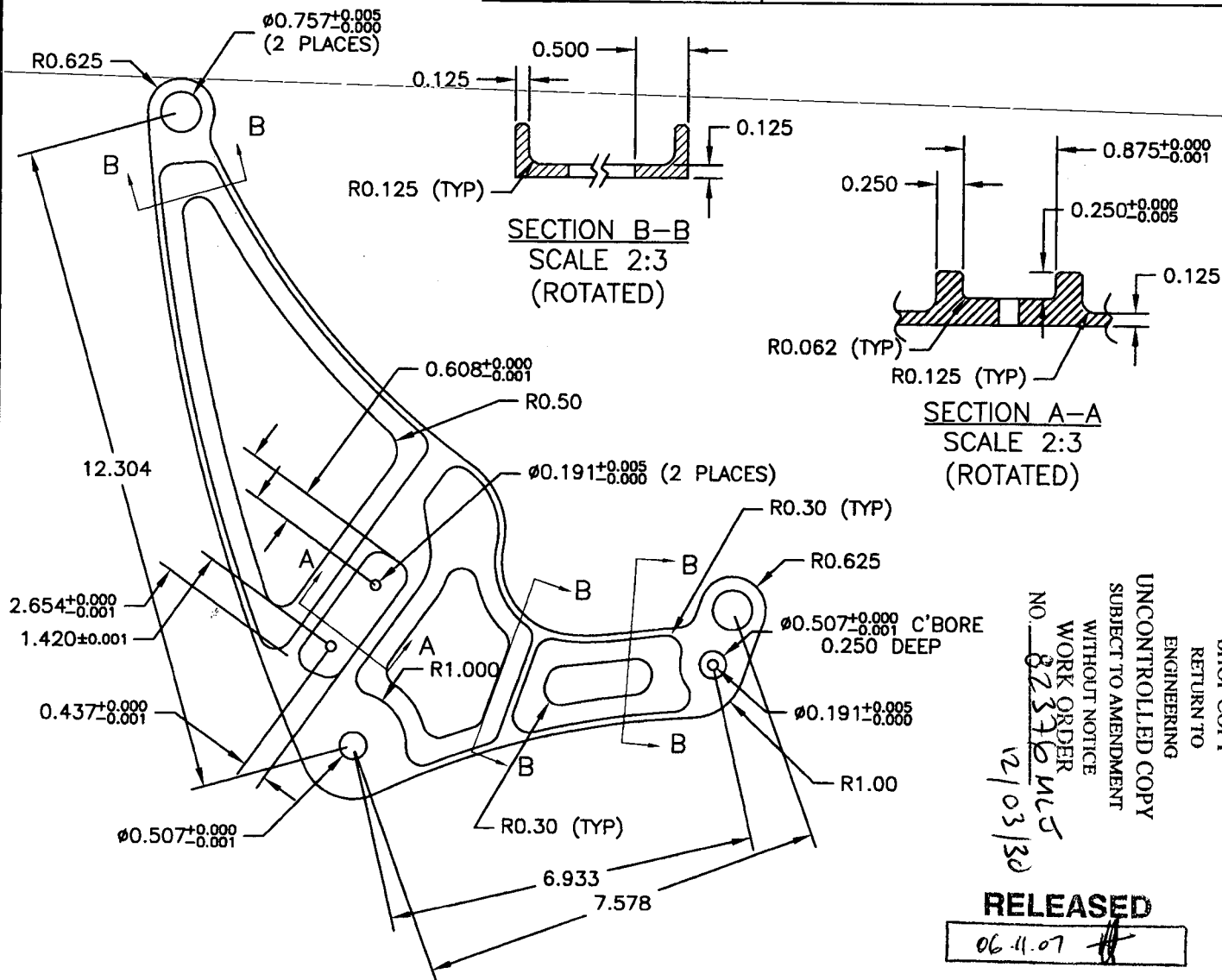
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	



**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

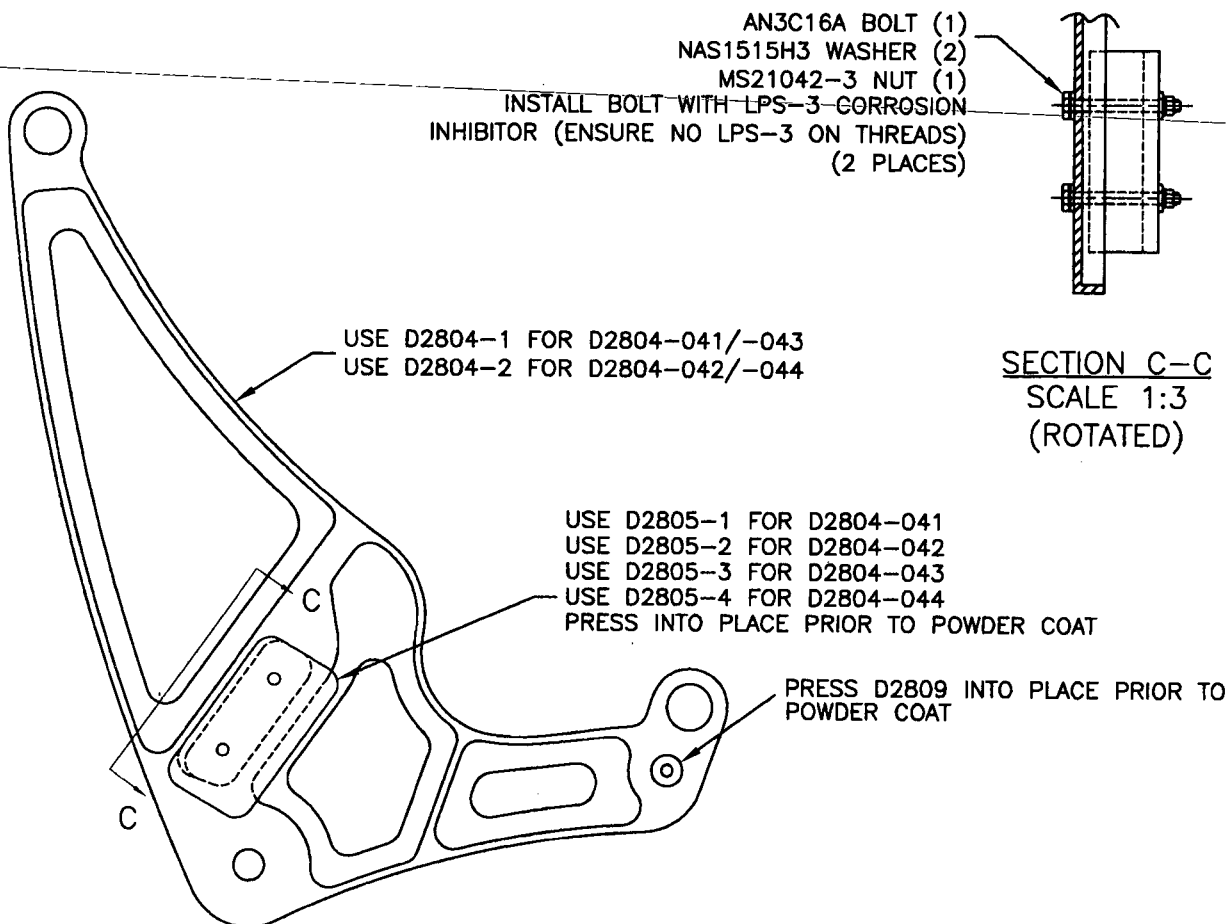
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



02376

RELEASED

06.11.07

D2804-041/-043 BRACKET ASS'Y (SHOWN).

D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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